

CLAIMS

1. A packaging and filling machine to obtain a container filled with food using a web-shaped laminated packaging material by processes of forming into a container and filling foods comprising:

a packaging material reel wound in a roll shape with a first packaging material laminated at least a support layer and a sealable inner most layer;

a film reel wound in a roll shape with a second packaging material comprising a outermost film and a container design layer printed on a surface of the outside or inside of said outermost film; and

lamination means to obtain said lamination packaging material by laminating said second packaging material unreeled from said film reel to the outside said support layer of said first packaging material unreeled from said packaging material reel.

2. The packaging and filling machine according to claim 1, wherein said laminated packaging material with pleat lines is formed into a tube shape, sealed vertically in the longitudinal direction, foods are filled in said tube-shaped packaging material, said tube-shaped packaging material is sealed laterally in the transverse direction, cut at said transverse sealing zone, and a final shape container is formed by folding along said pleat lines.

3. The packaging and filling machine according to claim 1, wherein said laminated packaging material with pleat lines is cut into a predetermined shape, blanks sealed vertically in the longitudinal direction of the container are obtained, sealed at the bottom of said blanks, filled with foods from the opening of said top portion, sealed said top portion.

4. The packaging and filling machine according to claim 1, wherein said laminated packaging material with pleat lines is cut into a predetermined shape, blanks sealed vertically in the longitudinal direction of the container are obtained, the lid portion of said blanks is formed by injection molding, foods are filled from the opening at the bottom portion of said blanks, and said bottom portion is sealed.

5. The packaging and filling machine according to claim 1, wherein said lamination means comprises at least two pressing rollers which press said first packaging material unreeled from said packaging material reel and said second packaging material unreeled from said film reel with each other.

6. The packaging and filling machine according to claim 5, wherein said pressing roller which presses said second packaging material is a heat roller.

7. The packaging and filling machine according to claim 5, wherein a laminate surface of said first packaging material unreeled from said packaging material reel and/ or that of the laminate surface of said second packaging material unreeled from said film reel are subjected to surface activation treatments such as corona discharge and flame treatment.

8. The packaging and filling machine according to claim 1, wherein said lamination means laminates said first packaging material unreeled from said packaging material reel and said second packaging material unreeled from said film reel by means of extrusion lamination.

9. The packaging and filling machine according to claim 1, wherein said first packaging material wound in a roll shape around said packaging material reel is the packaging material with pleat lines.

10. The packaging and filling machine according to claim 1, wherein said first packaging material wound in a roll shape around said packaging material reel is the packaging material without pleat lines, and said packaging and filling machine comprises crease means to provide said laminate packaging material obtained by said lamination means with pleat lines.

11. The packaging and filling machine according to claim 1, wherein the width of said second packaging material is wider than that of said first packaging material and the surplus portion of said second packaging material covers the surface of one or both ends of said first packaging material.